

Date: Sunday, 28/12/2008 1:50:02 PM  
User: Jean-Luc Menard

## **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE	
Job Number	: 44338				
Estimate Number	: 11175				
P.O. Number	:		Part Number	: D22825	
This Issue	: 28/12/2008	S.O. No. :	Drawing Number	: D2282 REV E	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: / /		Drawing Revision	: E	
Previous Run	: 44320		Material	:	
Written By	: <i>JLM 08-12-28</i>		Due Date	: 04/01/2009 Qty: 50 Um: Each	
Checked & Approved By					
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM				
	: EstRev:B Now on Doosan Lathe 08-06-05 JLM				
	Verified By:EC				
<b>Additional Product</b>					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	M304R0750	304 SS Roundbar .750 			
Comment:	Qty.: 0.1891 f(s)/Unit Total : 9.4532 f(s)				
Material:	AISI 304 Stainless Steel Ø0.750(M304R0.750)				
Batch:	<i>01110168 08/12/29</i>				
2.0	DOOSAN LATHE	DOOSAN LATHE 			
Comment:	DOOSAN LATHE				
1-Turn	as per Dwg D2282 and Folio FA189				
2-Deburr	<i>SD 08/12/31 08/12/29</i>				
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 			
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE <i>SD 08/12/31 08/12/29</i>				
4.0	QC8	SECOND CHECK 			
Comment:	SECOND CHECK <i>09/01/04 43</i>				
5.0	PACKAGING 1	PACKAGING RESOURCE #1 			
Comment:	PACKAGING RESOURCE #1				
Identify and Stock					
Location:	<i>ST25 09/01/05 X</i>				

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 44338

Part Number: D22825

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20/12/05

Job Completion



20/12/05

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<i>44338</i>
<b>Description:</b> Handle Tube	<b>Part Number:</b>	<b>D2282-5</b>
<b>Inspection Dwg:</b> D2282 <b>Rev:</b> E		<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

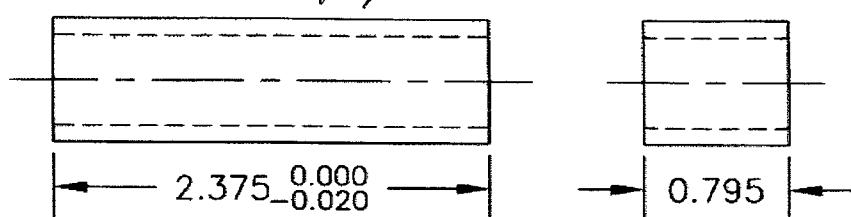
## X First Article      Prototype

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	08/12/29	Date:	09/01/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	DD

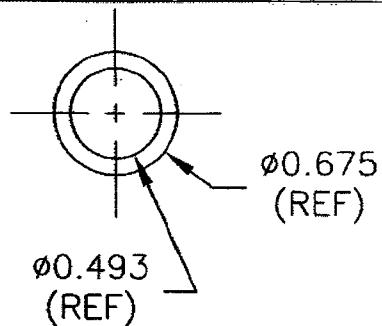
**DART**

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	



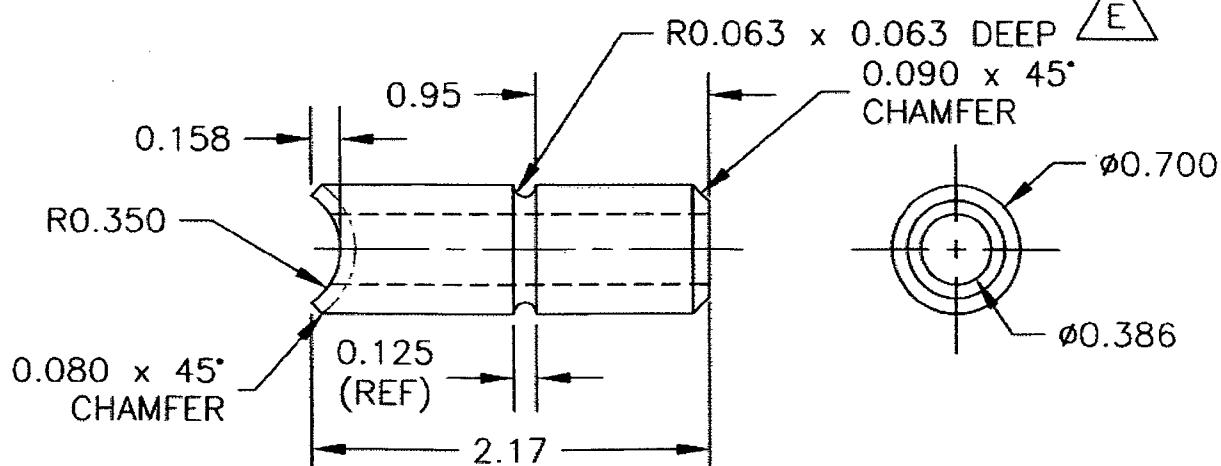
D2282-3

D2282-7



#### D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



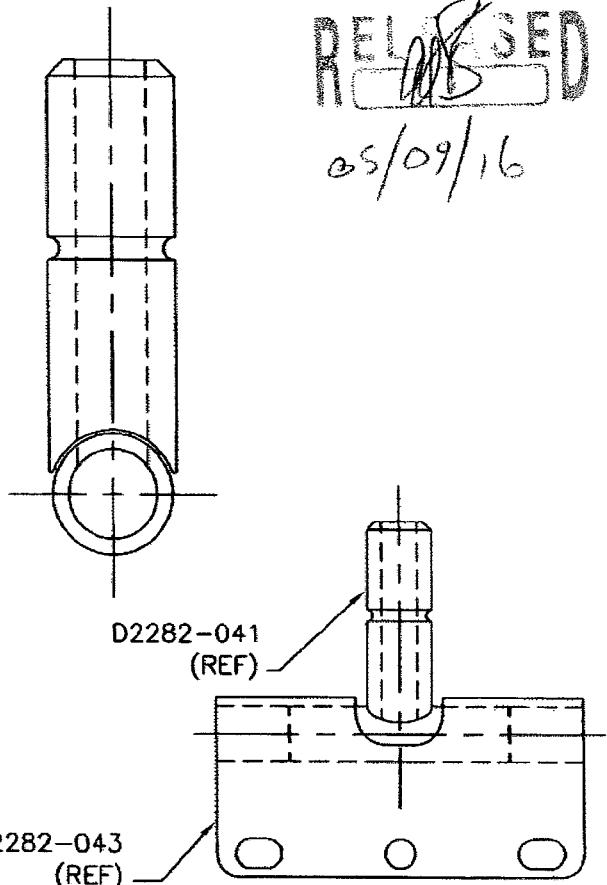
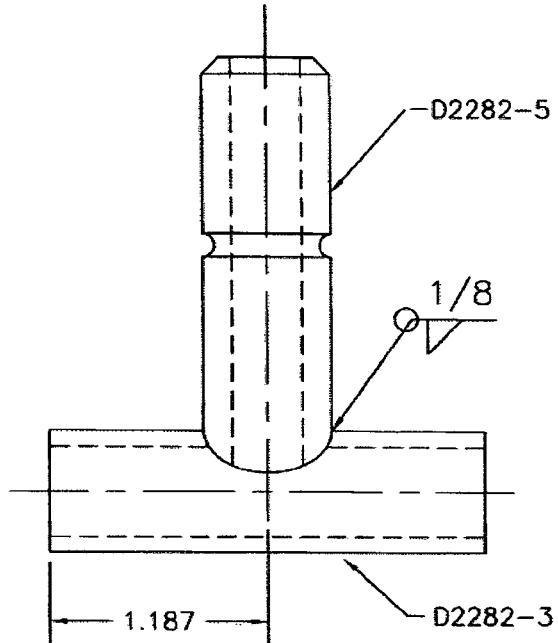
D2282-5

#### D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

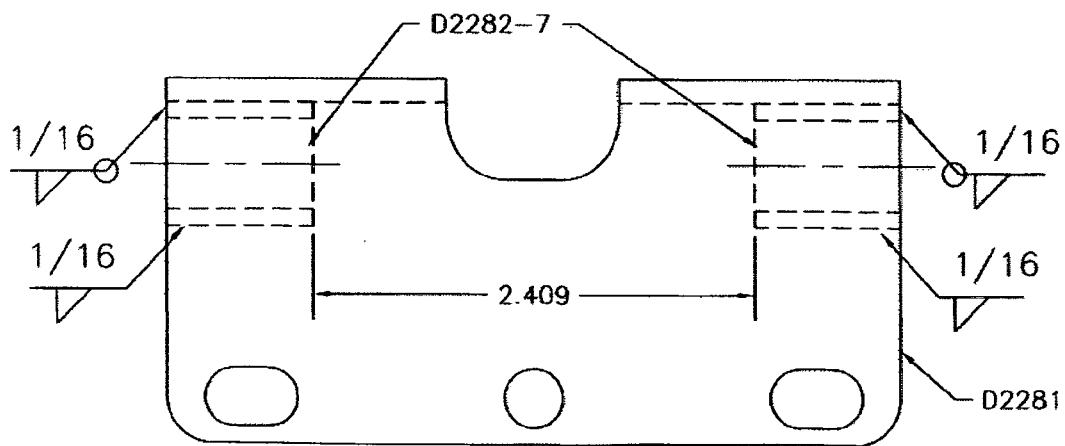


DESIGN BW	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004

GENERAL ASSEMBLY  
SCALE 1:2



D2282-043 SADDLE ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004

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